

**Work Order ID 70303**

Thursday, June 02, 2011 2:37:14 PM



Page 1

Item ID: D3208-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



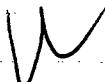
Start Date: 6/8/2011 Start Qty: 10.00



Required Date: 6/17/2011 Req'd Qty: 10.00



Reference:

Approvals: Process Plan: 

Date: Tooling:

Cust Item ID:

QC: \_\_\_\_\_

Date: SPC (Y/N):

Customer:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3208	Rev A1

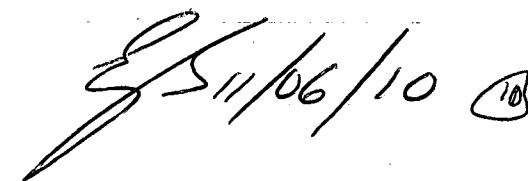
100 SHEAR 0.00

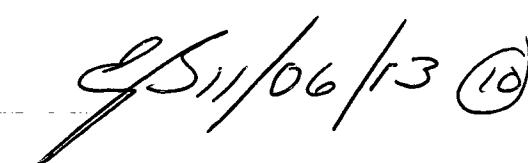
Shear **Memo** 0.00  
Cut blank: 4.038" X 5.340" grain along 4.038" Identify for D3208-1

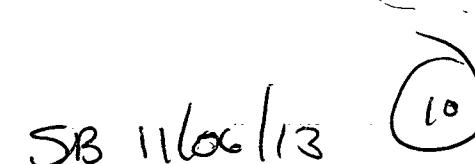
110 Small Fab 0.00

Small Fab **Memo** 0.00  
Drill and Fillet D3208-1 corner as per Dwg D3208. Identify as D3208-1

120 NC BRAKE 0.00

Brake NC **Memo** 0.00  
Deburr D3208-1. Form D3208-1 as per Dwg D3208. Polish any marks on part within 01. of Dwg D3208

 SF 11/06/10 (10)


 SF 11/06/13 (10)


 SB 11/06/13 (10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date &amp; initial all entries

# Work Order ID 70303

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Page 2

Item ID: D3208-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

ML 11 06 13 (10)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10XØ M-F 11/06/13

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 Ø BL 11-6-13.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 70303**

Thursday, June 02, 2011 2:37:14 PM



Page 3

Item ID: D3208-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

160



Packaging

Packaging

Identify as per dwg & Stock Location: 22Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/6/14 (10)**11/6/14  
MF  
11-06-14*

W/O:		WORK ORDER CHANGES						
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, June 02, 2011 2:37:12 PM

Page 1

Work Order ID: 70303



Parent Item: D3208-1



Parent Item Name: Doubler

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: - IPP: B 04.05.25 Material changed for Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	229.4000	0.1645	1.731579			

2024-T3 .040 sheet



Location	Loc Qty	Loc Code
MAT022	229.4	
112291	0.5	
112331	0.7	
113162	36.2	
117684	192	

1.731579  
JUN/06/10  
1.731579  
2003

W/O:		WORK ORDER CHANGES							
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

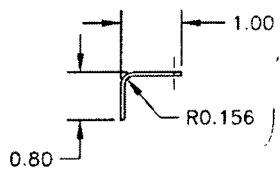
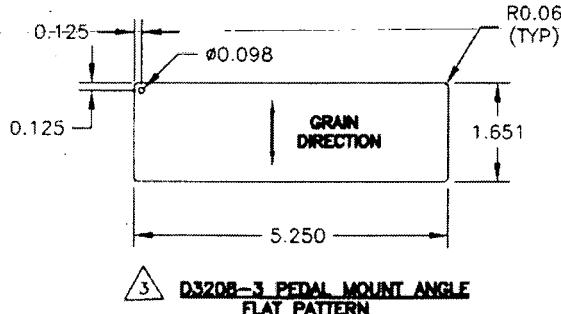
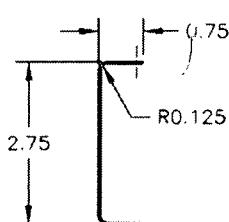
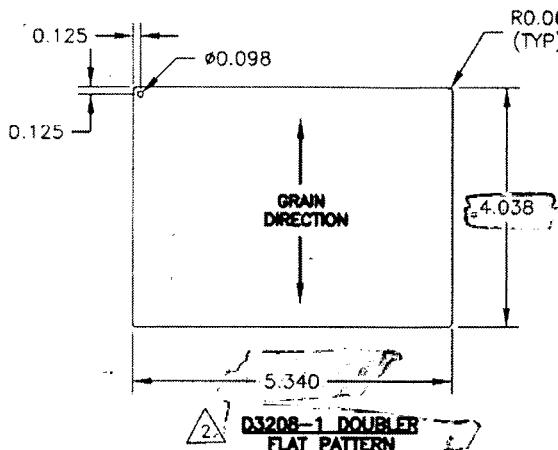
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DATE		DRAWING NO.	REV. A
04.01.27		D3208	SHEET 1 OF 3

RELEASED

41 100-0127 APR 18 2008  
100-0127 APR 18 2008



Wb70303

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

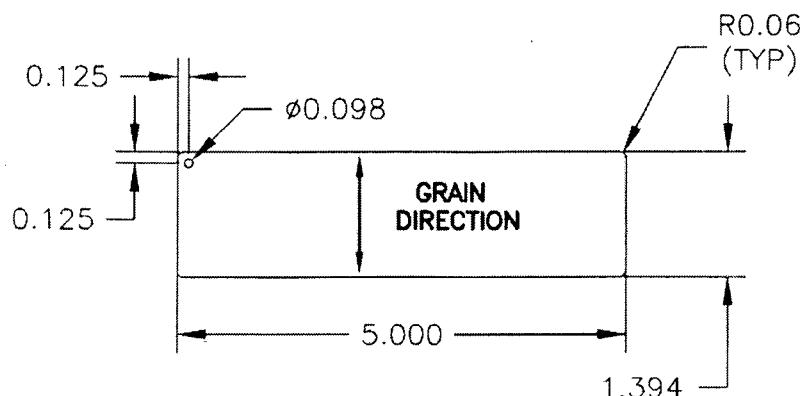
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



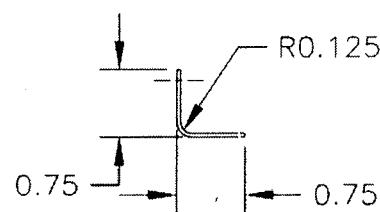
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DATE 04.01.27	TITLE DOUBLER		SCALE 1:2	

RELEASED  
04-04-05 *[Signature]*

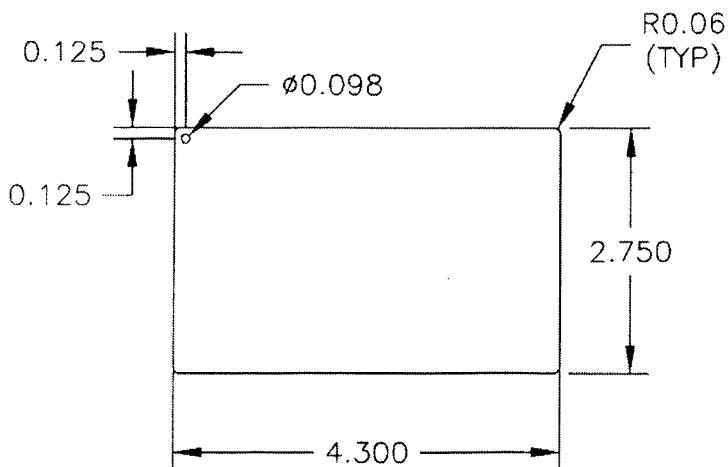


2

**D3208-5 MOUNT ANGLE  
FLAT PATTERN**

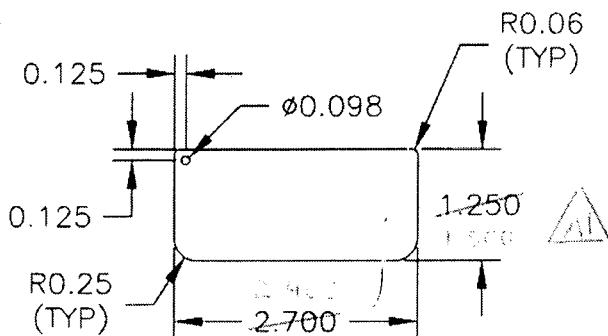


D3208-5 MOUNT ANGLE  
BEND DETAIL



2

**D3208-7 FILLER**



2

D3208-11 FILLER

1630<sup>3</sup>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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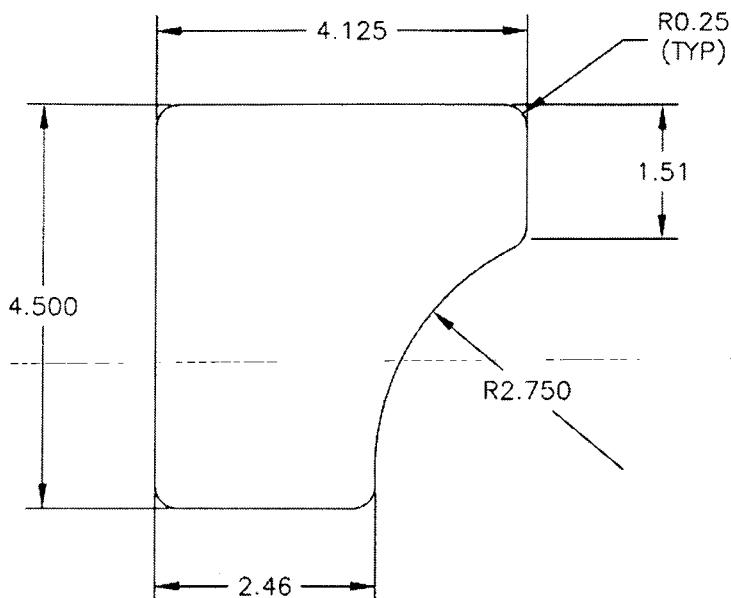
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DATE 04.01.27	TITLE DOUBLER	SCALE 1:2

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04.01.27



D3208-9 DOUBLER

70303

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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